



U.S. Department
of Transportation

**Pipeline and Hazardous
Materials Safety
Administration**

November 22, 2022

1200 New Jersey Avenue, SE
Washington, DC 20590

DOT-SP 21032
(FIRST REVISION)

EXPIRATION DATE: 2026-10-31

(FOR RENEWAL, SEE 49 CFR 107.109)

1. GRANTEE: Luxfer Inc.
d.b.a. Luxfer Gas Cylinders
Riverside, CA
2. PURPOSE AND LIMITATIONS:
 - a. This special permit authorizes the manufacture, mark, sale and use of non-refillable non-DOT specification fully-wrapped carbon fiber composite cylinders with a seamless aluminum liner conforming with all regulations applicable to ISO Standard 11119-2, except as specified herein, to contain oxygen for emergency oxygen supply at 5,000 psi. This special permit provides no relief from the Hazardous Materials Regulations (HMR) other than as specifically stated herein. The most recent revision supersedes all previous revisions.
 - b. The safety analyses performed in development of this special permit only considered the hazards and risks associated with transportation in commerce. The safety analyses did not consider the hazards and risks associated with consumer use, use as a component of a transport vehicle or other device, or other uses not associated with transportation in commerce.
 - c. In accordance with 49 CFR 107.107(a) party status may not be granted to a manufacturing permit. These packagings may be used in accordance with 49 CFR 173.22(a).
3. REGULATORY SYSTEM AFFECTED: 49 CFR Parts 106, 107 and 171- 180.
4. REGULATIONS FROM WHICH EXEMPTED: 49 CFR 173.302a(a) in that a non-DOT specification cylinder is not authorized except as specified herein; § 173.302(b)(4) in that the cylinder may not be charged above 3,000 psi except as specified herein;

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§§ 180.205 and 180.207 in that visual inspection is authorized in lieu of the hydrostatic pressure test.

5. BASIS: This special permit is based on the renewal application submitted by Luxfer Inc. dated October 3, 2022, and submitted in accordance with § 107.109.
6. HAZARDOUS MATERIALS (49 CFR 172.101):

Hazardous Material Description			
Proper Shipping Name	Hazard Class/ Division	Identification Number	Packing Group
Oxygen, compressed	2.2	UN1072	N/A

7. SAFETY CONTROL MEASURES:

a. PACKAGING: Packaging prescribed is a non-DOT specification fully wrapped carbon-fiber reinforced aluminum lined cylinder manufactured and marked in conformance with the ISO 11119-2 standard “*Gas cylinders — Refillable composite gas cylinders and tubes — Design, construction and testing — Part 2: Fully wrapped fiber reinforced composite gas cylinders and tubes up to 450L*”, except as follows:

- (1) The marked service pressure may not exceed 5,000 psi at a reference temperature of 15.0 °C. The water volume of the cylinders may not exceed 0.5L.
- (2) Cylinders are non-refillable and must be discarded after discharge.

b. TESTING: The cylinders must be tested in accordance with the ISO 11119-2 prototype design requirements except that:

Added: Burst test with Oxygen: The purpose of this test is to expose fresh aluminum metal to 5,000 psi oxygen environment by yielding the aluminum liner and bursting the cylinder.

- (1) Procedure: The cylinder maybe pre-conditioned to fail close to 5,000 psi by pre-flawing it or under-wrapping part of its surface. Remotely pressurize the test cylinder with oxygen to burst it at or above 5,000 psi. The burst pressure shall not be less than 4,500 psi. Monitor and record cylinder pressure with a pressure transducer during the test.

(2) Acceptable test results: The post burst cylinder and fragments shall be carefully inspected and if there is no evidence that the cylinder has burned, then the cylinder has passed the test.

c. OPERATIONAL CONTROLS:

(1) Cylinders manufactured under this special permit are not authorized to be refilled and must be discarded after use.

(2) Cylinders used in oxygen service must conform with § 173.302(b)(1)-(3).

(3) A cylinder that has been subjected to fire or heat damage may not be returned to service.

(4) Transportation of oxygen is only authorized when in accordance with § 175.501.

(5) Cylinders must be packaged in accordance with § 173.301(a)(9).

d. MARKING: The cylinder must be marked in accordance with § 178.71(q) except that the marking must contain the special permit number “DOT-SP 21032” in lieu of the ISO standard.

e. VISUAL INSPECTION: Cylinders must be visually reinspected at least once every five years. Inspection must be performed to the latest edition of CGA Pamphlet C-6.2 “Guidelines for Visual Inspection and Re-qualification of Fiber Reinforced High Pressure Cylinders”, except as specifically noted herein:

(1) Cylinders must not be hydrostatically tested.

(2) Reinspection markings must be applied on a label securely affixed to the cylinder and over-coated with epoxy, near the original test date. Metal stamping of the composite is prohibited. Reheat treatment of rejected cylinders is not authorized.

(3) Cylinders with fiber damage (cuts, abrasions, etc.) that exceeds Level 1 type damage as defined in CGA Pamphlet C-6.2 and meet the following depth and length criteria are considered to have Level 2 damage:

(i) Depth: Damage that upon visual inspection is seen to penetrate the outer fiberglass layer but does not expose the carbon layer beneath, or that has a measured depth of greater than 0.005 inch and less than 0.045 inch for cylinders with an outside diameter greater than 7.5 inches or less than 0.035 inch for cylinders 7.5 inches or less in outside diameter;

(ii) Length: Damage that has a maximum allowable length of:

Region	Direction of fiber damage	Maximum length of damage
Cylinder sidewall and domes	Transverse to fiber direction (longitudinal direction)	20% of the straight sidewall section length
Cylinder sidewall and domes	In fiber direction (circumferential direction)	20% of the straight sidewall section length

(4) Cylinders with damage that meets the Level 2 criteria must be rejected. Retesters must contact the cylinder manufacturer if the damage cannot be clearly interpreted based on these criteria. Cylinders with Level 2 type damage are not authorized to be repaired and must be condemned.

(5) Cylinders that have direct fiber damage that penetrates through the outer fiberglass layer and into the carbon layer, or that have a measured damage depth of greater than the Level 2 maximum are considered to have Level 3 type damage. Cylinders that have damage with depth meeting Level 2, but length exceeding the Level 2 maximum, are considered to have Level 3 type damage. Cylinders with Level 3 type damage are not authorized to be repaired and must be condemned.

(6) Persons who perform inspection and testing of cylinders subject to this special permit must comply with § 180.205(b) and with all the terms and conditions of this special permit.

8. SPECIAL PROVISIONS:

a. In accordance with the provisions of Paragraph (b) of § 173.22a, persons may use the packaging authorized by this special permit for the transportation of the hazardous materials specified in paragraph 6, only in conformance with the terms of this special permit.

b. A person who is not a holder of this special permit, but receives a packaging covered by this special permit, may reoffer it for transportation provided no modification or change is made to the packaging and it is offered for transportation in conformance with this special permit and the HMR.

c. A current copy of this special permit must be maintained at each facility where the package is offered or reoffered for transportation.

- d. Each packaging manufactured under the authority of this special permit must be either (1) marked with the name of the manufacturer and location (city and state) of the facility at which it is manufactured or (2) marked with a registration symbol designated by the Office of Hazardous Materials for a specific manufacturing facility.
- e. A current copy of this special permit must be maintained at each facility where the packaging is manufactured under this special permit. It must be made available to a DOT representative upon request.
9. MODES OF TRANSPORTATION AUTHORIZED: Motor vehicle, rail freight, cargo vessel, cargo-only aircraft, and passenger carrying aircraft.
10. MODAL REQUIREMENTS: A current copy of this special permit must be carried aboard each cargo vessel, aircraft or motor vehicle used to transport packages covered by this special permit. The shipper must furnish a copy of this special permit to the air carrier before or at the time the shipment is tendered.
11. COMPLIANCE: Failure by a person to comply with any of the following may result in suspension or revocation of this special permit and penalties prescribed by the Federal hazardous materials transportation law, 49 U.S.C. 5101 et seq:
- o All terms and conditions prescribed in this special permit and the Hazardous Materials Regulations, 49 CFR Parts 171-180.
 - o Persons operating under the terms of this special permit must comply with the security plan requirement in Subpart I of Part 172 of the HMR, when applicable.
 - o Registration required by § 107.601 et seq., when applicable.

Each "Hazmat employee", as defined in § 171.8, who performs a function subject to this special permit must receive training on the requirements and conditions of this special permit in addition to the training required by §§ 172.700 through 172.704.

No person may use or apply this special permit, including display of its number, when this special permit has expired or is otherwise no longer in effect.

Under Title VII of the Safe, Accountable, Flexible, Efficient Transportation Equity Act: A Legacy for Users (SAFETEA-LU) — "The Hazardous Materials Safety and Security Reauthorization Act of 2005" (Pub. L. 109-59), 119 Stat. 1144 (August 10, 2005), amended the Federal hazardous materials transportation law by changing the term

"exemption" to "special permit" and authorizes a special permit to be granted up to two years for new special permits and up to four years for renewals.

12. REPORTING REQUIREMENTS: Shipments or operations conducted under this special permit are subject to the Hazardous Materials Incident Reporting requirements specified in 49 CFR §§ 171.15 - Immediate notice of certain hazardous materials incidents, and 171.16 - Detailed hazardous materials incident reports. In addition, the grantee(s) of this special permit must notify the Associate Administrator for Hazardous Materials Safety, in writing, of any incident involving a package, shipment or operation conducted under terms of this special permit.

Issued in Washington, D.C.:



for William Schoonover
Associate Administrator for Hazardous Materials Safety

Address all inquiries to: Associate Administrator for Hazardous Materials Safety, Pipeline and Hazardous Materials Safety Administration, U.S. Department of Transportation, East Building PHH-13, 1200 New Jersey Avenue, Southeast, Washington, D.C. 20590.

Copies of this special permit may be obtained by accessing the Hazardous Materials Safety Homepage at <https://www.phmsa.dot.gov/approvals-and-permits/hazmat/special-permits-search>. Photo reproductions and legible reductions of this special permit are permitted. Any alteration of this special permit is prohibited.

PO: Casey Chambers